Work Ord Thursday, Aug				*123	3.372*						Page 1
Item ID: Revision ID: Item Name:	D3572-041 Guide			Accept	*N900	040	100)*	Setup St	art *	NS1* NS2*
Start Date: Required Date Reference:	8/15/14 e: 8/15/14	Start Qty: 4.00 Req'd Qty: 4.00	*4* *4*	ž	Cust Item 1 Customer:	ID:	·			•	
Approvals:	Process Pla	in: MLJ	Date: <u>\4-08</u> -	∑& Tooling:	D:	ate:	_			art *	JR1*
			Date:	SPC (Y/N):	Da	ate:			St	top *	JR2*
Sequence ID/ Work Center	ID	Operation Description	·	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Numbe	
Draw Nbr	Rev	vision Nbr ,				_	· · · · · · · · · · · · · · · · · · ·				
D3572	Rev	, D			• .						
*100 *100* Packaging	,44	Pick Kit Memo		0.00			·	_4_		¥	F 14-08-15
¹¹⁰ *11∩*		Small Fab		0.00				1,		 S	F 14-08-15
Small Fab Small Fab		Memo 1-Cut Tub 2-deburr b	pe D3572-1 as per Dwg D3 both ends	0.00 572						,,	<u> </u>
120 *120*	•	QC5- Inspect part com	apleteness to step on W/O	0.00				(4)		5	DAS DF 38 3 9-89
QC		Mama		0.00				<u> </u>	_	- (410 6 1	1) \\ \\ \\ \\ \\ \\ \\ \\ \\ \\ \\ \\ \\

Quality Control

WORK ORDER NON-CONFORMANCE / UPDATE Work Order: Disposition Dispos	Dr.
Work Order: Part No. Part No. Root Cause Date Step Oty Doc/Data Equip/Toolling Disposition Disposition Rework Scrap Against Department/PROCESS Skid-tube Crosstube Machining Small Fab Nachining Finishing Composite Crosstube Machining Small Fab Composite Composite Description of work order update Or non-conformance Design Doc/Data Equip/Toolling Disposition Against Department/PROCESS Water Jet Prod. Eng. Coor. Quality Thermoforming Large Fab Composite Description Description Against Department/PROCESS Water Jet Prod. Eng. Coor. Quality Cher Supplier Other Supplier Oct Chief Eng Description Oct Description Description Oct Descr	Dr.
Work Order: Part No.	or_
Part No. Part No.	or_
Part No. Scrap Use-as-is Suspected Unapproved Use-as-is Suspected Unapprove	or_
NCR No. Suspected Unapproved Suspected Unapproved Composite Supplier Other	or_
Root Cause Date Step Qty Description of work order update Doc/Data Equip/Tooling Large Fab Composite Supplier S	or_
Root Cause Date Step Qty Or non-conformance Chief Eng Description Date Verification QC Inspector Doc/Data Equip/Tooling Date Construction	or
Cause Date Step Qty or non-conformance Chief Eng Description Date Verification QC Inspector Design Doc/Data Equip/Tooling Date Step Qty Or non-conformance Chief Eng Description Date Verification QC Inspector Requip/Tooling Date Step Qty Or non-conformance Chief Eng Description Date Verification QC Inspector Oct. The step of t	or
Design Doc/Data Equip/Tooling	or
Doc/Data Equip/Tooling	
Equip/Tooling Equip ()	
Handling/Pre	
Material	
Operator	
Offset/Setup Offset/Setup	
Process Process	
Supplier	
Training	
Transport	
Unapproved	
FAULT CATEGORY	
Landing Gear General Bend Bend Bend Bend Bend Bend Bend Ben	ı
	ıra
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	lled
	icu
Crushing Countersink Misaligned/off center Positioned Wrong Heat Treat Cut Too Short Mislabeled Power Loss/Surge Other	
Inspection Strip in Tube Drawing Misread	
Marks/Chatter Drill Holes Off-set	
Turning Sequence Finish Out of Calibration	
Wave/Twist in Tube Fit/Function Out of Sequence	

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Work Order ID	123372
Thursday, August 07, 201	4 11:14:01 AM

123372

Page 2

		1.17.017111									
Revision ID:	D3572-041			Accept	*N900	<u>040</u>	100)* s	Setup Star Stop	1 71	S1*
	Guide 8/15/14 8/15/14	Start Qty: 4.00 Req'd Qty: 4.00	*4* *4*		Cust Item I Customer:	D:				* *N	S2*
Approvals:	Process Pla	n:	Date:	Tooling:	Da	ate:	-	R	Run Star Stop	^ I <i>V</i> I	R1*
	QC:		Date:	SPC (Y/N):	Da	ate:			Sioj	' *N	R2*
Sequence ID/ Work Center II)	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		Weld per dwg A/R Alur	minum rod Batch: M/2	9399 0.00							_
1 <u>2</u> 0 Large Fab		Large Fab Memo	•	0.00				4	<u>a</u>	14-8-	25
Large Fab		1-Weld D35 2- grind weld	72-3 guides and D3572-3 d flush at the end of tube	5 bracket as per Dwg D3572 only							
140		QC9- Inspect visual per (QSI004- Fusion Welds	0.00				.[AUG 2	6 2014	DAS 24 9-89
140 QC Quality Control		Memo		0.00				4			
											r .
150 ±4 F 0 ±		QC5- Inspect part comple	eteness to step on W/O	0.00				.1	AUG 2 6	2014	DAS 24
150 QC Quality Control		Memo		0.00				+			9-59

DQA:			_ Date:										*DART
QA Closed:			Date:			WORK ORDER NON	1-C(ONFO	RMANCE / UP		ork Order up	date only	AEROSPACE
Work Orde	r.	· · ·				DISPOSITION				AGAINST DI	PARTMENT,	PROCESS	
work Orde	'·	· · ·				Rework	٦		Skid-tube	Crosstube	7	Water Jet	Engineering
Part N	ο.					Scrap	1	L	Machining	Small Fab	Pro	d. Eng. Coor.	Quality
	_					Use-as-is		Thern	noforming	Finishing	Rec/Stor	e/Packaging	Other
NCR N	o					Suspected Unapproved]		Large Fab	Composite		Supplier	
Root					Desc	ription of work order update	,	Initial	Acti	on	Sign &		
Cause	4	Date	Step	Qty		or non-conformance	Ct	nief Eng	Descri	ption	Date	Verification	n QC Inspector
Design	_												
Doc/Data	4												
Equip/Tooling	_												
Handling/Pre	\dashv											i	
Material	-												
Operator	\dashv						1						
Offset/Setup Process	\dashv												
Supplier 🚜 🔊	\dashv			Ì									
Training A	\dashv	2014	16 2 8	À									
Transport -													
Unapproved					·								
					•		FA	ULT CA	TEGORY				
Landin	ng Ge	ear		·		General		_			_	_	
		Bending				Bend		Folio/F	Program		Outside Dim	ensions	Pressure/Forced
	\Box	Centre N	ot Concer	ntric		BOM/Route		Grain			Over/Under	tolerance	Set-up
3.7 S		Cracks	7 6 7 6	an,		Broken/Damage/Defect	L	Hardwa	are		Part Incorre	+	Temperature/Cure
[Crimp/Ki	nk/Ripple	/Wave		Burrs		Inspect	ion Incomplete/Un	qualified	Part Lost/Mi	ssing	Weld
		Cuffs			L	Contamination	L		tions Incomplete/U	Inclear	Part Moved	Į	Wrong Stock Pulled
· [Crushing				Countersink		-1	gned/off center		Positioned V		$\overline{}$
<u> </u>	ŀ	leat Tre	at			Cut Too Short	L	Mislabe			Power Loss/	Surge	Other
	_	•	on Strip in	Tube		Drawing	_	Misrea					
		Marks/Cl				Drill Holes	L	Off-set					<u>,</u>
].	_	_	Sequence			Finish		-	Calibration				_
	Wave/Twist in Tube					Fit/Function •		Out of	Sequence				

Work Order Thursday, Augus				*123					Page 3			
Item ID: Revision ID: Item Name:	D3572-041 Guide			Accept	*N900	040	100)*	Setup	Start Stop		S1* S2*
Start Date: Required Date: Reference:	8/15/14 8/15/14	Start Qty: 4.00 Req'd Qty: 4.00	*4* *4*	,	Cust Item II Customer:	D:						,
Approvals:	Process Pla	an:	Date:	Tooling:	Da	te:			Run	Start	*N	R1*
	QC:		Date:	SPC (Y/N):	Da	te:			Stop	*N	R2*	
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept	t Rej		Reject Number	Insp. Stamp
180		Chemical Conversion Co	oat per QSI005 4.1	0.00								
1 A \(\) HandFinish Hand Finishing		Memo	·	0.00				4x		14-8	3-27	DMC
¹⁹⁰		Grey Sandtex(Ref:4,3,5,	6) per QSI005 4.3	0.00				Н	ch	11/-	8-28	DAS 34 9-89
Douglargest		•		0.00					Ψ	<u> / / </u>	0 00	. <u>500 9</u>

200

QC3- Inspect Part Finish

0.00

0.00

200

Powdercoat Powder Coating

0.00

Quality Control

Memo

DQA:			Date:						_					TRACE
						WORK ORDER NON-	-CC	ONFO	RMANCE / UPE					AEROSPACE
QA Closed:			Date:					1		W	ork Order up	date only		
Work Orde	r:					DISPOSITION				AGAINST DI	PARTMENT	PROCESS		
Work Orac	•				 .	Rework			Skid-tube	Crosstube	7	Water Jet	\Box	Engineering
Part N	lo.					Scrap		1	Machining	Small Fab	Pro	d. Eng. Coor.	\exists	Quality
	•					Use-as-is		Thern	noforming	Finishing	Rec/Stor	e/Packaging		Other
NCR N	lo.					Suspected Unapproved			Large Fab	Composite]	Supplier		
Root					Desc	ription of work order update		Initial	Actio	n	Sign &			
Cause		Date	Step	Qty	Desc	or non-conformance		ief Eng			Date	Verification	n I	QC Inspector
Design														
Doc/Data														
Equip/Tooling														
Handling/Pre			ł										1	
Material														
Operator														
Offset/Setup			ļ											
Process			:											
Supplier									1					
Training														
Transport														
Unapproved						14 17.00								
							FA	ULT CA	TEGORY					
Landir	ng (Gear			_	General		, .		_	- 1	1		
		Bending				Bend	<u> </u>	4	Program	<u> </u>	Outside Dim		\vdash	Pressure/Forced
,		Centre N	ot Concer	ntric	<u> </u>	BOM/Route	_	Grain		ļ	Over/Under		Н	Set-up
		Cracks				Broken/Damage/Defect		Hardwa			Part Incorred			Temperature/Cure
		Crimp/Kii	nk/Ripple	/Wave	\vdash	Burrs	<u> </u>	4 '	ion Incomplete/Unqu		Part Lost/Mi	ssing	\vdash	Weld
	_	Cuffs			_	Contamination	<u> </u>	-	tions Incomplete/Un	clear	Part Moved		Ш	Wrong Stock Pulled
		Crushing			\vdash	Countersink	_		gned/off center	<u> </u>	Positioned V	•		Othor
		Heat Trea			<u> </u> _	Cut Too Short	<u> </u>	Mislabe		. L	Power Loss/	Surge	Ш	Other
		Inspectio	•	Tube	<u> </u>	Drawing	\vdash	Misrea						
		Marks/Ch				Drill Holes	<u> </u>	Off-set					-	
	<u> </u>	Turning S			<u> </u>	Finish	\vdash	-1	Calibration					
	Wave/Twist in Tube					Fit/Function	1	Out of S	Sequence					

Work Ord Thursday, Aug				*123				Page 4	4			
Item ID: Revision ID: Item Name:	D3572-041 Guide			Accept	*N900	040	100	ገ* ፡	Setup Star		IS1* IS2*	
Start Date: Required Date Reference:	8/15/14 e: 8/15/14	Start Qty: 4.00 Req'd Qty: 4.00	*4* *4*		Cust Item 1 Customer:	ID:						
Approvals:	Process Pl	an:	Date:	Tooling:	D	ate:	_	I	Run Stai	^I\	IR1*	
	QC:		Date:	SPC (Y/N):	D	ate:			Sto	* * \	IR2*	
Sequence ID/ Work Center	ID	Operation Description Identify as per dwg & St	ock Location:	Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	
910 Packaging Packaging		Мето		0.00				44	DAS 28 9-89	AUG	G 2 9 2014	
220		QC21- Final Inspection	- Work Order Release	0.00								

0.00

Memo

Quality Control

MLJ 1409-02 MLJ 1408-29

DQA: Date:						_	_	ΔART						
						WORK ORDER NON	-CC	ONFO	RMANCE / U	PDATE			_	AEROSPACE
QA Closed:			Date:	****						<u> </u>	Vork Order up	odate only		
Work Orde	er:					DISPOSITION				AGAINST D	EPARTMENT	/PROCESS		
Part N NCR N	-	·				Rework Scrap Use-as-is Suspected Unapproved			Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite		Water Jet d. Eng. Coor. re/Packaging Supplier		Engineering Quality Other
Root					Desc	ription of work order update		nitial	Act	tion	Sign &			
Cause	<i>"</i>	Date	Step	Qty		or non-conformance	Ch	ief Eng	Desci	ription	Date	Verification	1	QC Inspector
Design Doc/Data Equip/Tooling Handling/Pre Material 1 v. Operator Offset/Setup Process Supplier Training Transport Unapproved		Λ! Σ.1.												
							FA	ULT CA	TEGORY					
Landii	ng G	iear				General	_	-		-	_	r		
	Bending Centre Not Concentric					Bend BOM/Route Broken/Damage/Defect		Folio/F Grain Hardwa	Program	<u> </u>	Outside Dim Over/Under Part Incorre	tolerance	\exists s	Pressure/Forced Set-up Temperature/Cure
	Cracks			-	Burrs	-	4	ion Incomplete/U	ngualified	Part Lost/M	- F	_	Veld	
	Crimp/Kink/Ripple/Wave			\vdash	Contamination		4 '	tions Incomplete/	_	Part Moved	-	_	Vrong Stock Pulled	
	H H				Countersink	-	-	gned/off center	- F	Positioned V	L Vrong			
1 				Cut Too Short	<u> </u>	Mislabe	-	 	Power Loss/	· · · · · · · · · · · · · · · · · · ·	\Box	Other		
Inspection Strip in Tube Drawing					H	Misrea		· <u>L</u>						
				Drill Holes		Off-set				· .				
				Finish		4	Calibration					-		
Wave/Twist in Tube				Fit/Function	Out of Sequence									

Picklist Print

Thursday, August 07, 2014 11:14:00 AM

Work Order ID: 123372

Parent Item Name: Guide

123372>

Parent Item:

D3572-041

D3572-041

Start Date: 8/15/14

Required Date: 8/15/14

Start Oty: 4.00

Required Oty: 4.00

Comments:

IPP Rev:A New Issue 07-02-07 JLM

TIPP rev B revB dwg EC

IPP Rev:C Removed D3572-7 Cap 07-06-11 JLM

IPP Rev.D 08-05-27 Review process of IPP DD verified by:EC

	1 KCV.D 00-05-	2/ Review proc	CSS OI I	TF DD Veil	neu by:EC	V							
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3572-3		Manufactured	No			130	Each	23.0000	4	16			·
D3572-3				٠					**	E	14.8	-22	
				Location		Loc	<u>Oty</u>	Loc Code					
				WA002	_		23				_		
					110689		14		_	14	_		
					119368		9		_		_		
D3572-5		Manufactured	No			130	Each	7.0000	1	4			
D3572-5									**	Œ	7 /4	-8-25	
				Location		Loc	<u>Oty</u>	Loc Code				*,	
				WA002			7						
					102833		6			_3	_		
					89165)		1		_		_		
M6061T6T1.000W.188		Purchased	No			110	f	222.7463	2.34	10			
M6061T6 6061T6 RD TUBE 1.00 X .13		W 188		•.					**		FF	= 14-	08-1.

M6061T6T1 000W 188

•			,\$	
Location	Loc Oty	Loc Code		
MAT016	74.6443			
m128248	74.6443			
MAT030	148.102			
117797	19.25			10
120935	0.461			
121848	48			
122114	3.121			
m126686	77.27			

DQA:			Date:			. WORK ORDER NON	*DART						
QA Closed:			Date:			WORK ORDER NON	-C(JNFO	RIVIANCE / UF		/ork Order up	odate only	AEROSPACE
Work Ord	or:	e.				DISPOSITION				AGAINST D	EPARTMENT,	/PROCESS	ka.
VVOIR OIG	CI.					Rework	1		Skid-tube	Crosstube	7	Water Jet	Engineering
Part I	Vo.					Scrap	\		Machining	Small Fab	Pro	d. Eng. Coor.	Quality
	•			•		Use-as-is	1		moforming	Finishing	Rec/Sto	re/Packaging	Other
NCR I	No.					Suspected Unapproved]		Large Fab	Composite		Supplier	
Root					Desc	ription of work order update	П	nitial	Acti	ion	Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descri	iption	Date	Verification	QC Inspector
Design					:								
Doc/Data													
Equip/Tooling			<u> </u>										
Handling/Pre													
Material	<u> </u>												
Operator	ļ	ļ											
Offset/Setup	H	ł											
Process			ļ				1						
Supplier Training						g e ^{rt}							
Transport	\vdash	1										,	
Unapproved	Г	1	1.		,							·	
	1			·	d		FA	ULT CA	TEGORY				
Landi	ng (Gear				General						_	_
ء ا		Bending			· [Bend		Folio/l	Program	L	Outside Dim	ensions	Pressure/Forced
*		Centre N	ot Concer	ntric	· _	BOM/Route		Grain			Over/Under	tolerance	Set-up
		Cracks				Broken/Damage/Defect		Hardwa			Part Incorre	}	Temperature/Cure
September 1		Crimp/Ki	nk/Ripple	/Wave		Burrs		4	tion Incomplete/Ur		Part Lost/M	issing	Weld
٠,		Cuffs			.	Contamination			tions Incomplete/L	Jnclear	Part Moved	L	Wrong Stock Pulled
હા	<u>_</u>	Crushing				Countersink	L	4	gned/off center	· L	Positioned V	_	¬
	L	Heat Trea				Cut Too Short	<u></u>	Mislab		L	Power Loss/	Surge	Other
	<u> </u>	Inspectio		Tube	<u> </u>	Drawing	\vdash	Misrea					
,	$ldsymbol{f eta}$	Marks/Cl				Drill Holes	<u></u>	Off-set					
	<u></u>	4	Sequence		\perp	Finish	-	-	Calibration			<u></u>	J
	ľ	Wave/Tv	vist in Tub	эе		Fit/Function		Out of	Sequence				